

Date: Wednesday, 12/5/2007 10:35:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER	
Job Number	: 36142				
Estimate Number	: 11063				
P.O. Number	: N/A		Part Number	: D2935	
This Issue	: 12/5/2007 S.O. No. : N/A		Drawing Number	: D2935 REV B	
Prsh Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: 34174		Material	: N/A	
Written By			Due Date	: 12/24/2007 Qty: 40 Um: Each	
Checked & Approved By					
Comment					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet 2.66
		Comment: Qty.: 0.0532 sf(s)/Unit Total : 2.1294 sf(s) Material: M6061-T6 0.080" Thick Batch <u>106320</u> <u>HB 07-12-7</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2935 Dwg Rev: <u>B</u> <u>HB 07-12-7</u> Prog Rev: <u>B</u> 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 07-12-7</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE SPACER

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



50X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.J. 08/01/12

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 54

10-8/01/12 (50)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



50

Comment: FINAL INSPECTION/W/O RELEASE

P08102115

Job Completion



11-28-01-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36142
Description: Saddle Spacer	Part Number:	D2935
Inspection Dwg: D2935 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

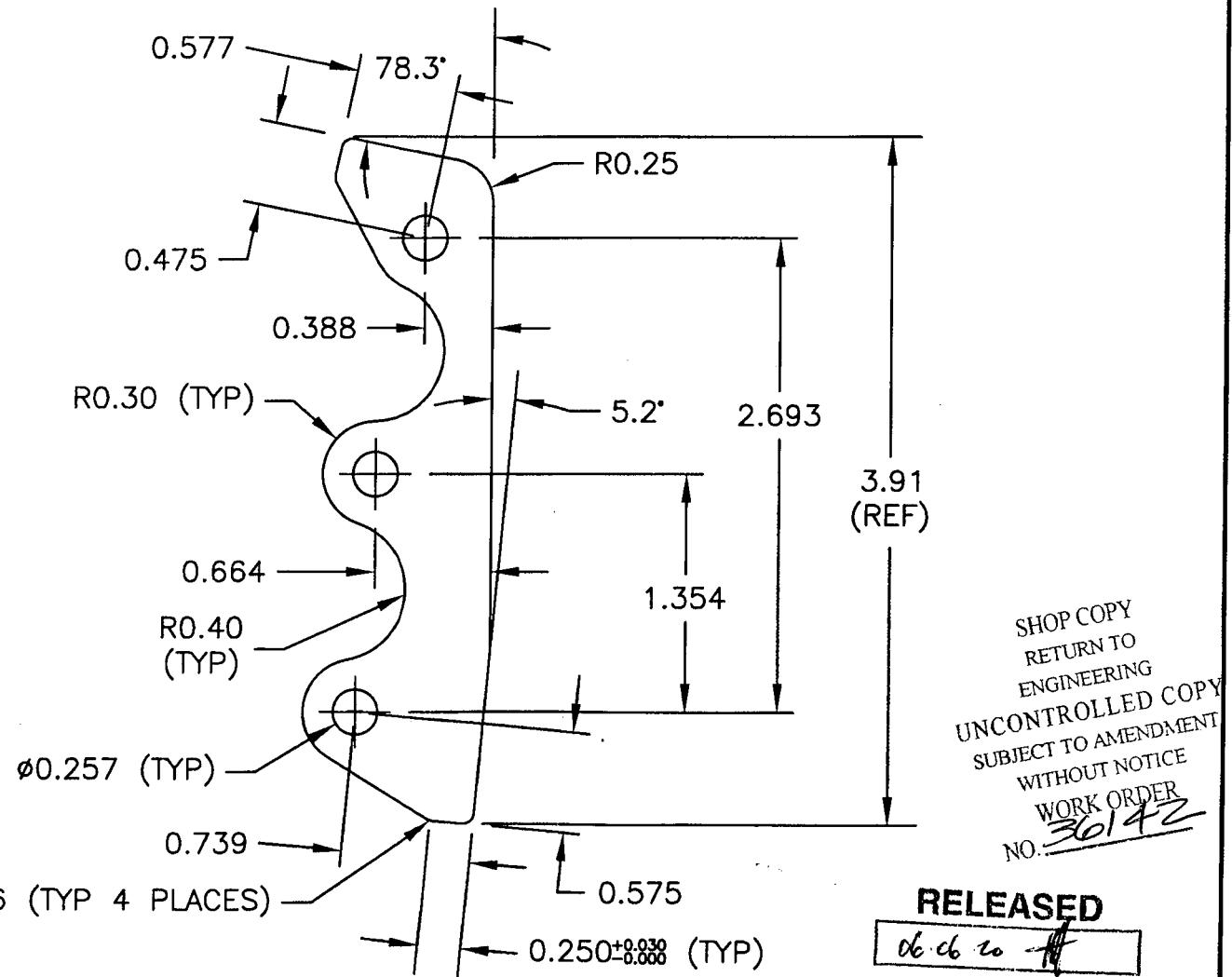
X First Article Prototype

Measured by: B	Audited by: C	Prototype Approval: N/A
Date: 07-12-7	Date: 08/01/12	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	
B	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN <i>FF</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>SM</i>	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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